



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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014176

646.4001
Job Sheet 201391



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/19

Job Tracking No:

Due Date: 10/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	10/24/19	10/24/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3	DAS	
							Packaging 1 - 4	74	
							Packaging 1 - 5	9-89	JAN 29 2020
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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CANADA
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Container No: S252006



Part: 646.4001

Job No: 201391

Serial No/Batch: S252006

Revision:

Inspector:

Exp Date: 06/27/2020

Instructions: FAA STC SR02180LA 14/08/07, T6, STC SH09 -

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	QC 4	1 pcs	10/24/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	F.D. DAS 69 9-89
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
					QC 4 - 78	
130	Packaging 3-1 - Stock - B4B	1 pcs	10/24/19	0.00 0.00	Packaging 3 - 1 - B4B	F.D. DAS 69 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135	DC - 1 - B4B	1 pcs	10/24/19	0.00 0.00	DC - 1 - B4B	DAS 21 9-89 FEB 04 2020
					DC - 2 - B4B	
140	QC 21 - FG	1 pcs	10/24/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	DAS 21 9-89 FEB 04 2020
					QC 21 - FG - 53	
Part Op 110 - pick kit						
Descriptions: 120 - QC4- 100% Inspect kits for completeness						
Plex 10/2/19 2:47 PM Dart.lajeunesse.mari						

- 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
 135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5215203
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5241630
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5241651
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5240535
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5221122
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5220095
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5238266
646.3110	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192731
646.3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5221454
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5250764
646.3510	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5187254
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183035
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5230345
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5244582
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218358
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183061
646.3713	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219291
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192814
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218112
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233890
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5190396
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5219261
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218795
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220046
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5229025
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220084
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5171341
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5236294
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5220038
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218498
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218110
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056498
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5248131
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5249432
650.9201	Eyelet Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5239706
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5241218
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5218358
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5194345
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5221895
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216385
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5194345
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5221999
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216370
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5222451
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5239635
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5218602
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5235456
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	FM13392-36
MS20470AD5-5-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5155675
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048897
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5203251
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5250462
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5243985
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5228833
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5235694

exp-date
 09-20-2020
 09-20-2020

MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5202672	
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5188069	533343
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5228823	
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5173068	
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5123937	
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5157316	
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5143131	
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5157063	
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5216386X14	512 3443X8
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5228014	
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5171793	
NAS1149F0332P	Washer (AN960-10L)	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5249219	
NAS1149F0363P	Washer (AN960-10)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5025330	
NAS1149F0432P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5225459	5222492
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5235228	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	434	0
	600.0990	1	17	0
	600.0991	1	16	0
	600.1012	1	31	0
	600.1013	5	25	0
	646.2910	1	8	0
	646.3001	1	8	0
	646.3110	1	14	0
	646.3210	1	9	0
	646.3301	1	8	0
	646.3510	1	37	0
	646.3511	1	38	0
	646.3610	1	11	0
	646.3710	1	25	0
	646.3711	1	34	0
	646.3712	1	14	0
	646.3713	1	15	0
	646.3714	1	18	0
	646.3715	2	44	0
	646.3716	1	28	0
	646.3717	1	24	0
	646.3718	2	25	0
	646.3719	2	50	0
	646.3810	2	17	0
	646.3811	1	18	0
	646.3812	2	10	0
	646.3813	1	25	0
	646.3910	4	53	0
	646.3911	1	15	0
	646.3912	4	85	0
	646.3913	1	32	0
	646.9410	1	48	0
	647.0112	2	16	0
	647.7703	2	10	0
	650.9201	2	5	0
	AN3-11A	10	213	0
	AN3-12A	2	140	0
	AN3-13A	1	33	0
	AN3-3A	4	218	0
	AN3-4A	10	191	0
	AN3-5A	2	268	0
	AN3-6A	2	278	0
	AN316C4R	2	47	0
	AN44-5A	2	55	0
	AN4C7A	2	57	0
	AN665-34R	2	46	0
	CCR264SS3-02	36	1,204	0
	CR3213-5-3	14	218	0
	MS20426AD5-7	2	647	0
	MS20470AD5-5-5	8	761	0
	MS20470AD5-6	8	598	0

MS20470AD5-7	3	1,020	0
MS21042L08	2	1,122	0
MS21042L3	63	3,311	0
MS21042L4	2	1,627	0
MS21047-3	18	440	0
MS24693-C278	5	86	0
MS24694-S51	5	238	0
MS24694-S54	2	126	0
MS24694-S55	3	192	0
MS27039-08-13	2	319	0
MS27039-1-10	2	218	0
MS27039-1-12	6	207	0
MS27039-1-16	24	540	0
MS27039-1-19	22	435	0
MS27039-1-20	2	52	0
MS27039-1-21	4	107	0
NAS1149F0332P	144	3,143	0
NAS1149F0363P	2	312	0
NAS1149F0432P	4	789	0
NAS1149FN832P	4	1,709	0

Part Specifications

Specifications could not be found.

Plex 10/2/19 2:47 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

NOTES:

- 8

4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC
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05304

41	601.2829	SCREW	MS24694554	
40	601.2831	RIVET	MS20426AD5-7	
39	646.3716	GAUGE BRACKET		
38	601.1953	SCREW	MS27039-1-12	
37	646.3715	STRUT DOUBLER		
36	601.2824	BOLT	AN3-5A	
35	601.2277	RIVET	CC89M455-02	
34	600.0795	NUPLATE	MS21047-3	
33	601.2565	RIVET	MS20470AD5-7	
32	646.3813	STRUT BRACKET		
31	601.2822	BOLT	AN3-3A	
30	646.3812	GUSSET BRACKET		
29	601.2564	RIVET	MS20470AD5-6	
28	646.3714	GUSSET		
27	646.3610	FILLER		
26	601.2830	SCREW	MS24694555	
25	601.2825	BOLT	AN3-6A	
24	646.3811	RADIUS BLOCK		
23	646.3712	CLIP		
22	646.3711	CLIP		
21	601.2832	RIVET	MS20470AD5-5	
20	601.2020	RIVET	CR3213-3-3	
19	601.2823	BOLT	AN3-4A	
18	601.2827	BOLT	AN3-3A	
17	601.2912	SCREW	MS24694551	
16	646.3713	GUSSET		
15	646.3210	SUPPORT		
14	646.3710	DOUBLER		
13	646.3110	CHANNEL		
12	601.1624	LOCKNUT	MS21042L3	
11	601.1607	WASHER	NAS1147G320P	
10	646.3410	LH WIPER DEFLECTOR		
9	646.3411	RH WIPER DEFLECTOR		
8	647.7703	STRUT ASSY		
7	647.0112	STRUT BRACKET		
6	646.3511	STRUT		
5	646.3510	STRUT		
4	646.3810	BRACKET		
3	646.2910	DEFLECTOR		
2	646.3001	LOWER CUTTER ASSY		
1	646.3301	UPPER CUTTER ASSY		
	646.4006	LOWER CUTTER FIBER PROVISIONS		
	646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
	646.4004	FIBER PROVISIONS KIT		
	646.4003	CABLE CUTTING KIT WITHOUT FIBER PROVISIONS		
	646.4002	ASS30 WIPER DEFLECTOR KIT		
	646.4001	ASS30 CABLE CUTTERS KIT		
IND #	PART #	DESCRIPTION	MATL	SPEC.

					2				41	601.2829	SCREW		MS24694554
					2				40	601.2831	RIVET		MS20426AD5-7
					1				39	646.3716	GAUGE BRACKET		
					6				38	601.1953	SCREW		MS27035-1-12
				2					37	646.3715	STRUT DOUBLER		
		2		2					36	601.2824	BOLT		AN3-5A
12		36							35	601.2277	RIVET		CER29455-02
6		18							34	600.0795	NUTPLATE		MS21047-5
3		3							33	601.2565	RIVET		MS20470AD5-7
1		1							32	646.3813	STRUT BRACKET		
4		4							31	601.2822	BOLT		AN3-3A
2		2							30	646.3812	GUSSET BRACKET		
8		8							29	601.2564	RIVET		MS20470AD5-5
1		i							28	646.3714	GUSSET		
		1		1					27	646.3610	FILLER		
		3		3					26	601.2830	SCREW		MS24694555
		2		2					25	601.2825	BOLT		AN3-6A
		1		1					24	646.3811	RADIUS BLOCK		
		1		1					23	646.3712	CLIP		
		1		1					22	646.3711	CLIP		
		8		8					21	601.2832	RIVET		MS20470AD5-5
14		14							20	601.2020	RIVET		CR3213-5-3
4		6		4					19	601.2823	BOLT		AN3-4A
		1		1					18	601.2827	BOLT		AN3-3A
		5		5					17	601.2912	SCREW		MS24694551
		1		1					16	646.3713	GUSSET		
		1		1					15	646.3210	SUPPORT		
		1		1					14	646.3710	DOUBLER		
		1		1					13	646.3110	CHANNEL		
14	10	8		53		6		61	12	601.1624	LOCKNUT		MS210426-3
16	32	18		120		16		144	11	601.1607	WASHER		NAS11-01FC320P
						1			10	546.3410	LH WIPER DEFLECTOR		
						1			9	646.3411	RH WIPER DEFLECTOR		
				2				2	8	647.7203	STRUT ASSY		
				2				2	7	647.0112	STRUT BRACKET		
				1				1	6	646.3511	STRUT		
				1				1	5	646.3510	STRUT		
2		2						2	4	646.3810	BRACKET		
				1				1	3	646.2910	DEFLECTOR		
				1				1	2	646.3001	LOWER CUTTER ASSY		
				1				1	1	646.3301	UPPER CUTTER ASSY		
X										646.4006	LOWER CUTTER FIXED PROVISIONS KIT		
	X									646.4005	LOWER CUTTER REMOVABLE PROVISIONS KIT		
		X								646.4004	FIXED PROVISIONS KIT		
			X							646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS		
				X						646.4002	ASS30 WIPER DEFLECTOR KIT		
					X					646.4001	ASS30 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	FIND #			PART #		DESCRIPTION	MATEL	SPEC.

QTY		PARTS LIST	
NEXT AVAIL (\$)		ORIGINAL DATE 02-23-88 DRAWN BY S. HUFF DESIGNED BY P. BRAYD CHECKED BY P. BRAYD APPROVED BY J. HANCOCK #740	 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300 APCAL INDUSTRIES, INC. (aka DART AEROSPACE)
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE ARE 2 PLACES DECIMALS 0.00 3 PLACES DECIMALS 0.005 ANGLES 0.5°		SIZE B	ASS305 CABLE CUTTERS KIT KIT # CAGE CODE DMD NO. REV. B D7M16 646.4000 C SCALE NONE 1 SHEET 1 OF 5